

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013094**Date Inspected:** 07-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Tian Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

Bay -1

This QA inspector observed, ZPMC qualified welding personnel identified as 215397 perform Flux Core Arc Welding (FCAW), weld joint identified as 20 TR1-003, ZPMC QC identified as Mr.Xiang Feng Teng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2232-TC-U4C-F

This QA inspector observed, ZPMC qualified welding personnel identified as 216872 perform Flux Core Arc Welding (FCAW), weld joint identified as 20 TR1-040, ZPMC QC identified as Mr.Xiang Feng Teng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2232-TC-U4C-F

This QA inspector observed, ZPMC qualified welding personnel identified as 059450 perform Flux Core Arc Welding (FCAW), weld joint identified as 20 TR2-050, ZPMC QC identified as Mr.Xiang Feng Teng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with

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WPS-B-T-2232-TC-U4C-F

This QA inspector observed, ZPMC qualified welding personnel identified as 216575 perform Flux Core Arc Welding (FCAW), weld joint identified as 20 TR2-024, ZPMC QC identified as Mr.Xiang Feng Teng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2232-TC-U4C-F

Bay # 2

This QA inspector observed, ZPMC qualified welding personnel identified as 045270 perform Submerge Arc Welding (SAW), weld joint identified as FB3188-001-002, ZPMC QC identified as Mr.Zhu Lin. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2221-B-L2C-S-2

This QA inspector observed, ZPMC qualified welding personnel identified as 045270 perform Submerge Arc Welding (SAW), weld joint identified as FB3185-001-006, ZPMC QC identified as Mr.Zhu Lin. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2221-B-L2C-S-2

Bay # 2

This QA inspector observed, Heat Straightening Perform ZPM QC is identified as Mr. Yang Qing Teng. The variables recorded by QC appeared to comply with the Heat Straightening Report (HSR) was HSR1 (B) -8160.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj
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Quality Assurance Inspector

Reviewed By:	Miller,Mark
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QA Reviewer
